

Date: Tuesday, 11/29/2005 3:06:17 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 25019	Part Number	: D2574		
Estimate Number	: 10534	Drawing Number	: D2574 REV D		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 11/29/2005	S.O. No.	: N/A		
Prsh't Rev.	: NC	Drawing Revision	: D		
First Issue	: N/A	Material	: N/A		
Previous Run	: 24840	Due Date	: 1/5/2006		
Written By	<u>See COMMENT Below</u>			Qty:	8
Checked & Approved By	<u>See ABOVE DATE & USEC</u>			Um:	Each
Comment	: Est: H 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B21817A (1)</u> <u>B25204</u>	J.G. 06/01/16 8
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>25019</u> Double check by: <u>SJ</u>	J.G. 06/01/16 MS 06/01/18
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. N/A	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	-MS 06/01/18 -J.G. 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 25019

Part Number: D2574

Job Number:



Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE - M8 06/01/18 - J.G.
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
7.0	POWDER COATING	POWDER COATING
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
9.0	PACKAGING 1	PACKAGING RESOURCE #1
10.0	DC	DOCUMENT CONTROL

Comment: INSPECT PARTS AS THEY COME OFF MACHINE 8

Comment: SECOND CHECK BG 06.01.24 8

Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 FF 06-02-09 8

Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 DL 06/02/19 8

Comment: INSPECT POWDER COAT CL06102120 8

Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST480 CL06102120 8

Comment: DOCUMENT CONTROL Inspection Level 21 SU 06/02/21 8 DD 06/02/21 8

Job Completion



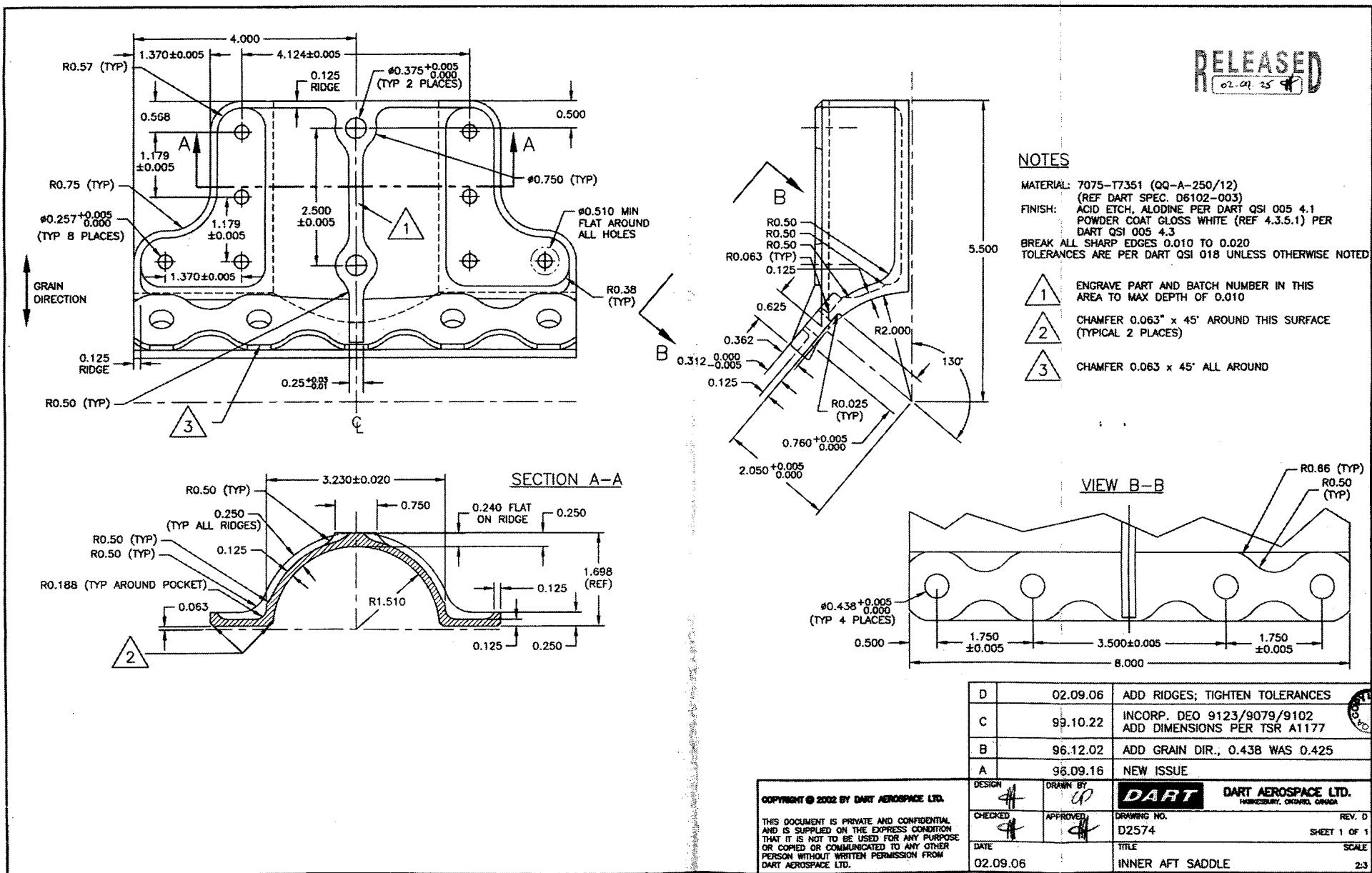
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
DRAWING NO. D2574	REV. D SHEET 1 OF 1
TITLE INNER AFT SADDLE	SCALE 2:3

DART AEROSPACE LTD

Work Order:

25019

Description: Saddle, Aft Inboard

Part Number:

D2574

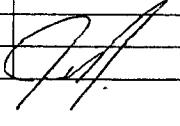
Inspection Dwg: D2574 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.747		
C	3.495	3.505		3.500	3.500	3.500	3.497		
D	1.745	1.755		1.750	1.750	1.750	1.748		
E	7.990	8.010		8.002	8.003	8.004	8.004		
F	0.490	0.510		.505	.503	.506	.500		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.502	.504	.505	0.499		
J	1.174	1.184		1.180	1.180	1.180	1.179		
K	0.558	0.578		.571	.574	.574	0.569		
L	1.174	1.184		1.180	1.180	1.180	1.179		
M	1.365	1.375		1.370	1.370	1.369	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.497		
O	4.119	4.129		4.121	4.124	4.124	4.120		
P	0.115	0.135		.126	.125	.127	0.128		
Q	0.115	0.135		.135	.135	.135	0.135		
R	0.240	0.260		.250	.250	.250	0.251		
S	0.115	0.135		.126	.125	.125	0.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.234	3.232	3.231		
V	0.230	0.250		.243	.241	.240	0.241		
W	0.115	0.135		.125	.125	.125	0.125		
X	0.307	0.312		.308	.311	.311	.309		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.365	.360	.362	0.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.629	.629	0.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.248	.246	0.247		
AE	1.500	1.520		1.511	1.511	1.511	1.511		
AF	0.115	0.135		.135	.135	.135	0.135		
AG	0.240	0.280		.272	.270	.270	0.271		
AH	0.240	0.260		.252	.248	.250	0.249		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		.03	.03	.03	.03		
Accept/Reject									

Measured by: M8 /
Date: 06/01/18Audited by: J.G
Date: 06/01/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
05/12/05

DART AEROSPACE LTD

Work Order:

25019

Description: Saddle, Aft Inboard

Part Number:

D2574

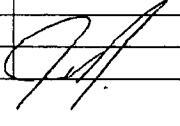
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D	1.745	1.755		1.747	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.003	8.004	8.003		
F	0.490	0.510		0.500	.499	.499	.502		
G	0.257	0.262	DT8683	0.260	✓	✓	✓		
H	0.375	0.380	DT8684	0.377	✓	✓	✓		
I	0.490	0.510		0.4985	.501	.501	.500		
J	1.174	1.184		1.178	1.180	1.180	1.180		
K	0.558	0.578		0.570	.568	.572	.575		
L	1.174	1.184		1.176	1.180	1.180	1.180		
M	1.365	1.375		1.360	1.370	1.370	1.370		
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P	0.115	0.135		0.128	.125	.125	.126		
Q	0.115	0.135		0.134	.135	.135	.135		
R	0.240	0.260		0.250	.247	.250	.250		
S	0.115	0.135		0.124	.125	.123	.123		
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U	3.210	3.250		3.230	3.231	3.231	3.231		
V	0.230	0.250		0.234	.240	.240	.240		
W	0.115	0.135		0.122	.125	.125	.125		
X	0.307	0.312		0.312	.310	.310	.310		
Y	0.760	0.765		0.760	.762	.762	.762		
Z	0.352	0.372		0.356	.356	.359	.356		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.622	.626	.623	.621		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.246	.248	.246	.247		
AE	1.500	1.520		1.510	1.511	1.511	1.511		
AF	0.115	0.135		0.130	.135	.135	.135		
AG	0.240	0.280		0.265	.269	.270	.270		
AH	0.240	0.260		0.246	.251	.251	.251		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	.03	.03	.03		
Accept/Reject									

Measured by: /MS
Date: 06/01/21Audited by: J.G.
Date: 06/01/21

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A		New Issue	RF	
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